

Work Order ID 116441

April-16-14 8:32:35 AM

116441

Page 1

Item ID: PB67-43001-253

Revision ID:

Item Name: Gusset

Start Date: 4/16/14

Start Qty: 8.00

8

Required Date: 5/01/14

Req'd Qty: 8.00

8

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MCS

Date: 14-04-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg B67-43001

Dwg Rev: C

Prog Rev:

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

110

110

QC

Quality Control

0.00

0.00

0.00

0.00

8

8

14.04.16

8

8

14.04.16

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Page 2

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Accept

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Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

27

9-19

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: M-222

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14-4-16

91

Picklist Print

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Page 1

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Parent Item: PB67-43001-253

PB67-43001-253

Parent Item Name: Gusset

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A new issue 08.06.19 DD verified: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.125

Purchased

No

100

sf

180.2330

0.1289

2

M6061T6S 125

14.04.14

6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT021

180.233

m127272

38.5

m127454

63.333

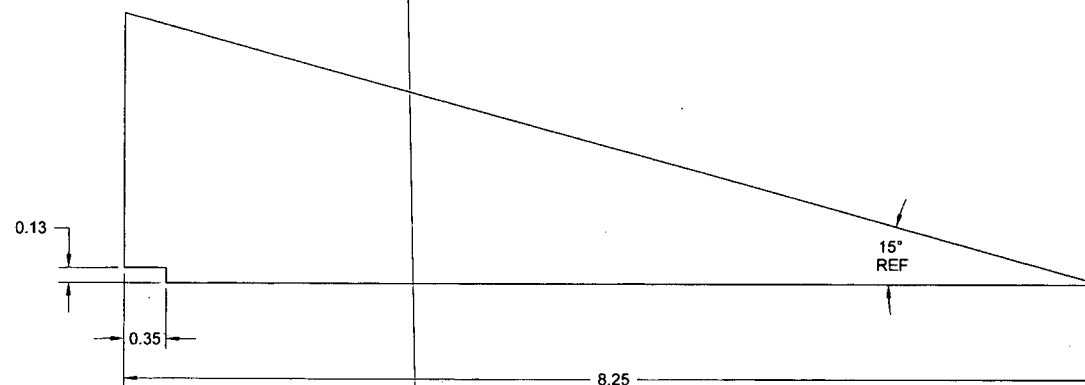
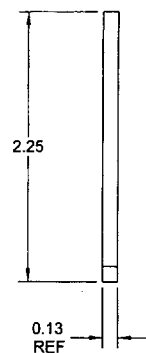
m127501

14.4

m128852

64

2



B67-43001-253 GUSSET

116441 MJS
14-04-16

RELEASED
2009-09-24
MP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 23 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	ASB	DRAWING NO. B67-43001-253		REV. C
MFG. APPR.				SHEET 1 OF 1
APPROVED	MP	TITLE GUSSET		SCALE
DE APPR.	N/A			NTS
DATE	09.03.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		